

Work Order ID 71157

Thursday, June 23, 2011 12:43:43 PM



Page 1

Item ID: D4150-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Attachment Arm Assembly

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 11-06-23 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4150

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

11/07/20 (4)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11.07.20 (4)

120

Identify as per dwg & Stock Location: 134

0.00



Packaging

Memo

0.00

Packaging

11/8/21 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/22

11-07-21
(4)

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Picklist Print

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Page 1

Work Order ID: 71157

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly





Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A  Bolt		Purchased	No			100	Each	54.0000	2	8		6/21/07/20	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST351		54							
					115768	4							
					117366	50							
D4150-1  Arm		Manufactured	No			100	Each	0.0000	1	4		6/21/07/20	
D4150-3  Arm Plate		Manufactured	No			100	Each	4.0000	2	8		6/21/07/20	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST133		4							
					69629	4							
MS21043-3  Nut		Purchased	No			100	Each	1,177.000	2	8		6/21/07/20	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		72							
					103691	72							
				ST301		1105							
					112314	105							
					118077	1000							

B71158 (40)

B71605

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Picklist Print

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Work Order ID: 71157

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly



Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0332R

Purchased

No

100

Each

1,293.000

4

16



Washer



EP 11/07/20

Location

Loc Qty

Loc Code

FP-B

15

117291

15

ST297

1278

116304

55

117460

260

117887

563

118078

400

16

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Shop Packet Print

Page 2

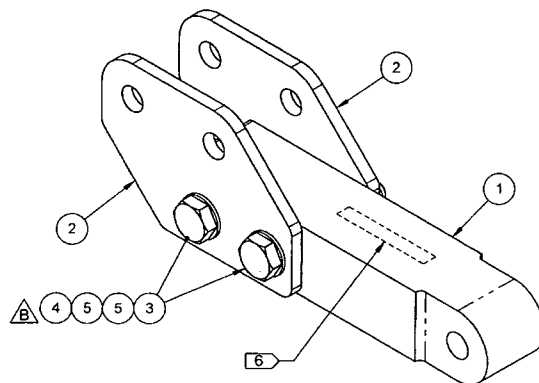
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D4150-041 ATTACHMENT ARM ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

ITEM	QTY	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2, C7-2, B4-3 & B5-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4150	REV. B SHEET 1 OF 3
TITLE ATTACHMENT ARM ASSY	SCALE NTS
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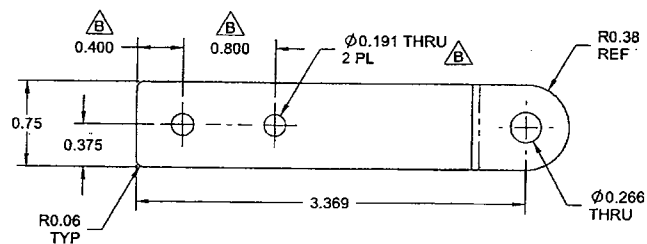
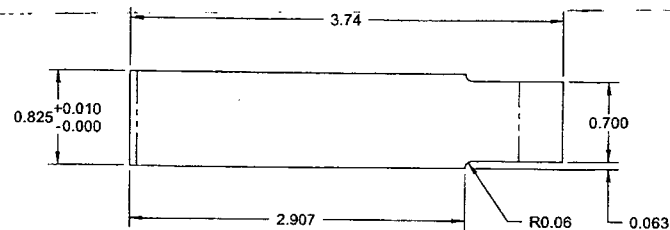
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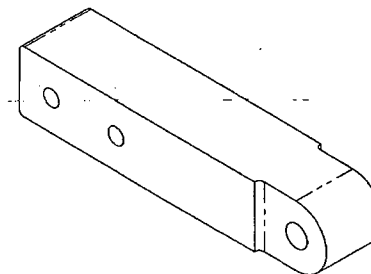
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D4150-1 ARM



#71157

RELEASED
2010-07-16
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	10.07.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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